

## Acrylic System A15GB

- Cast Resin on Acrylic Basis -



The acrylic system A15GB is a medium-viscosity combination of resin and mineral powder on solvent-free water basis.

### Features & Benefits:

- low heat generation
- easy to use and odourless
- possible addition of water up to 5%
- mixable with dry colour pigments
- addition of cotton flakes to increase the viscosity
  
- creation of decorative and technical elements
- production of sculptures and reliefs
- creation of detailed models

### Product Properties:

Mixing ratios (by weight)	100 parts resin : 300 parts mineral powder		
Working time (pot life)	10-20 minutes	(100g at 20°C)	
Demoldable	60-120 minutes	(100g at 20°C, layer thickness 30mm)	
Mechanically loadable	8h	(100g at 20°C, layer thickness 30mm)	
Hardening age	24h	(100g at 20°C, layer thickness 30mm)	
Working temperature	15 - 25 °C		

### Product Specifications:

Viscosity A (25°C)	30-50	cps	PM.01.003
Viscosity hardener (25°C)	Powder		visual

### Data of unreinforced resin:

Density	ca. 1,75	g/cm <sup>3</sup>	PM.01.002
Shrinkage	<0,5	%	PM.01.002
Hardness (Shore D)	84		PM.01.009
Bending strength	15	MPa	PM.01.005
Pressure resistance	35	MPa	PM.01.022
Colour (mixed)	beige		visual
Heat resistance	75	°C	PM.01.008

**Safety instructions:**

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The safety instructions are to be taken as being of greatest importance. Do not allow children to handle. Prevent inhalation of the fumes and contact with the bare skin. Wear approved protective gloves and goggles. If ingested do not eat, drink or smoke. During the hardening process, energy can be released in the form of heat, hence a cooling/heat exchanging should be provided in order to prevent hot spots. Only mix the components in the recommended proportions in accordance with the instructions.

**Application Instructions:**

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We recommend tests be performed for trials and suitability for the particular type of application. The system should only be used in the optimum temperature conditions. The relative air humidity should not be above 70%.

In respect of the safety instructions the Silicone and hardener should be mixed in a suitable mixing vessel in accordance with characteristics given in the data sheet. Deviating from the mixing recommendations can lead to incomplete hardening and through that loss of performance.

Ensure that the edges are well mixed using a stirring stick or a propeller type mixer. Localized signs of hardening indicate insufficient stirring and mixing of the components. Mixing of larger amounts (more than 100g) and higher temperatures (higher than 20°C) reduces the pot life time.

After entire mixing of resin and hardener, it is possible to add dry filling agents.

Further it is possible to degas the system by vacuum at 30 – 50 mbar.

- Vacuum may increase the volume!

Note: If the temperature in the process go above 40°C then it is not possible to continue further, as the process will lead to a loss of certain characteristics and properties. Increases temperature can be reduced by pouring the mixture into flat painting trays.

**Cleaning work tools:**

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Unhardened product remains can be removed from tools by means of acetone or Thinner XB. Tools should be given a good airing after being cleaned with these solvents, in order to prevent the solvent from being retained until the tool is used again in a process. Hardened remains can only be removed by departing.

**Storage:**

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Threaded container tops should be kept free of material remains. Do not exchange tops/lids.

With optimal storage conditions, shelf-life should be beyond 6 months.

**Deliverable quantities:**

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Plastic containers with safety fastening in different quantities.

- The delivered amounts always contain equal proportions of Silicone and hardener! -

Larger containers can be obtained upon request.

**Disposal:**

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Do not dispose of through the sewerage system, on areas of open water, or in the soil. Non-hardened remains of the product should be disposed of as hazardous waste. The hardened product waste should be treated as building rubbish or household rubbish.

**Further Information:**

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Further application information can be obtained from our internet site, by selecting product info on the homepage. Please do not hesitate to contact us by telephone if you have further queries.

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With the newest printing of this data sheet the previous version loose validity!